Tuesday, 13/05/2008 9:28:07 AM Julie Lecoca User: Customer Job Number P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By Comment **Additional Product** Job Number: Seq. #: 1.0

Process Sheet

: CU-DAR001 Dart Helicopters Services : 39222 Estimate Number : 10725

: 13/05/2008

: NC

: //

: 38815

Drawing Name

Part Number

: D2652

: BUSHING

Drawing Number Project Number D2652 REV A

Drawing Revision

: N/A

Material

Due Date

: 05/06/2008

300 Um: Qty:

Each

Checked & Approved By

: Est Rev:B 02.06.13

Type

S.O. No. :

Now machined in house.

: MACHINED PARTS

NG



Machine Or Operation:

Description:

M303R0500

303 Round Bar 0.500"



Comment: Qty.:

0.0578 f(s)/Unit Total: 17.3250 f(s)

Material:303 ss .500" Round Bar

(M303R0500)

Batch: M 106996

2.0



Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652

FOLIO REV: 41 DWG REV: 4

2-DEBURR AS REQUIRED

3.0

QC2





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0



SECOND CHECK



Comment: SECOND CHECK

QC8

PACKAGING RESOURCE #1



5.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock 1 Location:



J.F.

Dart Aerospace Ltd

W/O:		7	WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE	i ii	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				*						
Dort No.			DAD # Foult Cotomons	NO	D V.	N. DO		D-4	1	

QA: N/C Closed: ____ Date: ____

NCR:		D	·	Corrective Action Section B		\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Approval Chief Eng	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval QC Inspector
							G.	

NOTE: Date & initial all entries

Date:

Tuesday, 13/05/2008 9:28:07 AM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 39222

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/27/4

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-26

Dart Aerospace Ltd

W/O:								
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		OF CONTRACTOR OF THE CONTRACTO		·				
		-						
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date:	

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Varification				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
		·						
					,	,		
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		~					-	
		,						

NOTE: Date & initial all entries

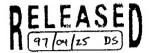
DART AEROSPACE LTD	Work Order: 39222
Description: Bushing	Part Number: D2652
	V 1
Inspection Dwg: D2652 Rev: A	Page 1 of 1

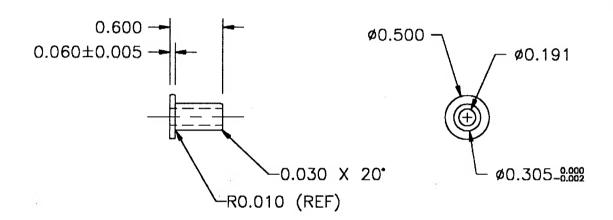
Inspection Dwg	j: D2652 Re v	v: A				F	age 1 of 1
	FIRS	T ARTICLE II	NSPECTI	ON CH	ECKLIST		
		X First Arti			totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
0.600	+/-0.010	.600					
0.060	+/-0.005	.058					
Ø0.305	-0.002/+0.000	8.304	V			14.0	
Ø0.191	+0.005/-0.000	8.191	V	9			0.91
Ø0.500	+/-0.010	\$ 499	√			7.	
0.030 x 20°	+/-0.010	.036× 40°	V,				
R0.010	+0.010/-0.000	010.8					
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Measured by:	nnt/22	Audited by:	DIN		Prototype App		N/A
Date:	08/05/15	Date:	08/05/1	<u> </u>		Date:	NA
Rev Date	Change	<u> </u>			R	evised by	Approved

Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	*



	DESIGN	DRAWN BY		ROSPACE U	
)	CHECKED	APPROVED	DRAWING NO. D2652	· .	REV. A SHEET 1 OF 1
	DATE		TITLE		SCALE
	97:03:25		BUSHING		1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTEBOOPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE